

**AMENDMENTS TO THE SPECIFICATION:**

Please replace the paragraph beginning at page 2, line 16 with the following:

The proposed object is met according to the present invention in that the geometrical shape of the inner cross-section of the mold and the corresponding dimensions thereof conform ~~are analogous~~ to a curve of the locally deducible quantity of solidification heat for a specified casting rate and ~~analogous~~ to the expansion of the tubular mold. The tubular mold is thereby adapted so as to optimize the process, wherein the solidification heat is dissipated according to a (high) casting rate based on the mold height (mold length) both by means of the casting contraction behavior as well as the mold expansion during casting operation.

Please replace the paragraph beginning at page 4, line 21 with the following:

Taking into account the decreasing contraction according to the respective casting shell thickness, it is further provided that the approximately parabola-shaped recess formed in the wall

of the mold ~~casting~~ by the recession ~~contraction~~ declines in the direction toward the casting exit side. This makes it possible to carry out an individualized adjustment to the respective broadside and/or narrowside of the entry cross-section, the broadside and narrowside being equal if the cross section of the mold is square.

Please replace the paragraph beginning at page 5, line 11 with the following:

In a further embodiment a surface is provided in the area of each corner radius which is parallel to the plane ~~plane-parallel~~ and opposes analogous counter surfaces in the inner cross-section form.

Please replace the paragraph beginning at page 7, line 1 with the following:

The tubular mold 2 is built such that the inner geometrical cross-section shape 9 of the mold and the associated dimensions 10, 10' thereof are set to correspond ~~analogous~~ to the locally deducible quantity of solidification heat (see Fig. 1, right diagram "D") for a specified (high) casting rate and analogous to

the expansion of the tubular-mold 2, i.e., designed based on calculations and/or experience.

Please replace the paragraph beginning at page 7, line 8 with the following:

The exterior shape ~~form~~ 12 is thereby reduced at least in separate height ranges 12' of the tubular mold 2 analogous to the thermal expansion of the mold.

Please replace the paragraph beginning at page 7, line 13 with the following:

The values for the expansion or the contraction of casting metals may also be taken into account in the geometrical cross-section shape ~~form~~ 9 depending on the specific steel grade on hand.

Please replace the paragraph beginning at page 8, line 15 with the following:

The length 20a of the parabola-shaped recess 20 thereby extends approximately into half the height of the mold 11. The

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length 20a of the parabola-shaped recess 20 is also adapted to an amount of contraction along ~~of~~ the height of the respective broadside and/ narrowside 21 of the mold cross-section 22 (Fig. 4A).

Please replace the paragraph beginning at page 8, line 21 with the following:

In the area of each corner radius 8 there is one surface 23 extending downwards, and a respective analogous opposing counter surface 24 in the inner cross-section shape 9, the surfaces 23 and 24 being in parallel planes ~~plane-parallel~~.